







Date: Tuesday, 16/09/2008 1:21:59 PM  
User: Julie Lecocq

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 42025	
Estimate Number : 10709	
P.O. Number :	Part Number : D32101
This Issue : 16/09/2008 S.O. No. :	Drawing Number : D3210 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39820	Material :
Written By :	Due Date : 30/09/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 08.9.16</u>	
Comment : Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now On Waterjet 06-10-24 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M2024T3S080 2024-T3 .080 sheet
	
<p>Comment: Qty.: 2.6177 sf(s)/Unit Total : 26.1765 sf(s)</p> <p>Material: 2024-T3 (QQ-A-250/4) 0.080" thick</p> <p>(M2024T3S.080)Identify as D3210-1</p> <p>Batch: <u>109424</u> <u>IB 8-10-1</u></p>	
2.0	WATER JET FLOW WATER JET
	
<p>Comment: FLOW WATER JET</p> <p>1-Cut as per Dwg D3210</p> <p>Dwg Rev: <u>A</u> <u>IB 8-10-1</u></p> <p>Prog Rev: <u>A</u></p> <p>2-Deburr if necessary <u>IB 8-10-1</u></p>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>	
4.0	QC8 SECOND CHECK
	
<p>Comment: SECOND CHECK</p> <p><u>S 08/16/02</u> <u>(+10)</u></p>	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	
<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</p> <p>Deburr</p> <p><u>~ / 4 Done at 5:00 2-2</u></p> <p><u>S 08/16/02</u></p>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 42025

Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

802/09 F10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 08-10-02 (XU)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00  
320 OF  
12:30

ML 08/10/03

(11X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F12 08/10/03 (11)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57210 R 8/10/06 (11)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08

Job Completion



u 08-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. A
DATE		D3210	SHEET 1 OF 1
03.09.03		TITLE	SCALE
		DOUBLER	1:3
A	03.09.03	NEW ISSUE	

# D3210-1 DOUBLER

MAKE PER DRAWING FILE "D3210-A1.DWG"

CHECK PER TEMPLATE D3210-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.09.03

DETAIL A  
SCALE 2:3

